ASAP

Work Order ID 110000

December-16-13 1:07:29 PM

110000

Item ID: D4952-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Wearplate **Stop** *NS2*

Start Date: 12/16/13 **Start Qty:** 40.00 *40* **Cust Item ID:**

Required Date: 12/20/13 **Req'd Qty:** 40.00 *40* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4952	A								
110	FLOW WATER JET	0.00				40	0		Ae 13.12.16
110									
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Rev: A								
	Prog Rev: A								
	2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				40	0		Ae 13.12.16
120									
QC	**Memo**	0.00							
Quality Control									

Work Order ID 110000

December-16-13 1:07:29 PM

110000

Item ID: D4952-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Wearplate

Start Date: 12/16/13 **Start Qty:** 40.00 *40*

Required Date: 12/20/13 **Req'd Qty:** 40.00 *40*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00 27 9-89				40			
130 QC Quality Control	Memo	0.00 BJ 12/17				OOW			
140	Identify as per dwg & Stock Location: WA007	0.00				(40)		312	13.12.17
140 Packaging Packaging	Memo	0.00							
150	QC21- Final Inspection - Work Order Release	0.00						13/12/18	
150 QC Quality Control	Memo	0.00							

13-12-18

Picklist Print

December-16-13 1:07:28 PM

Work Order ID: **110000**

Parent Item: **D4952-1** **Start Date:** 12/16/13 **Required Date:** 12/20/13

Parent Item Name: Wearplate **Start Qty:** 40.00 **Required Qty:** 40.00

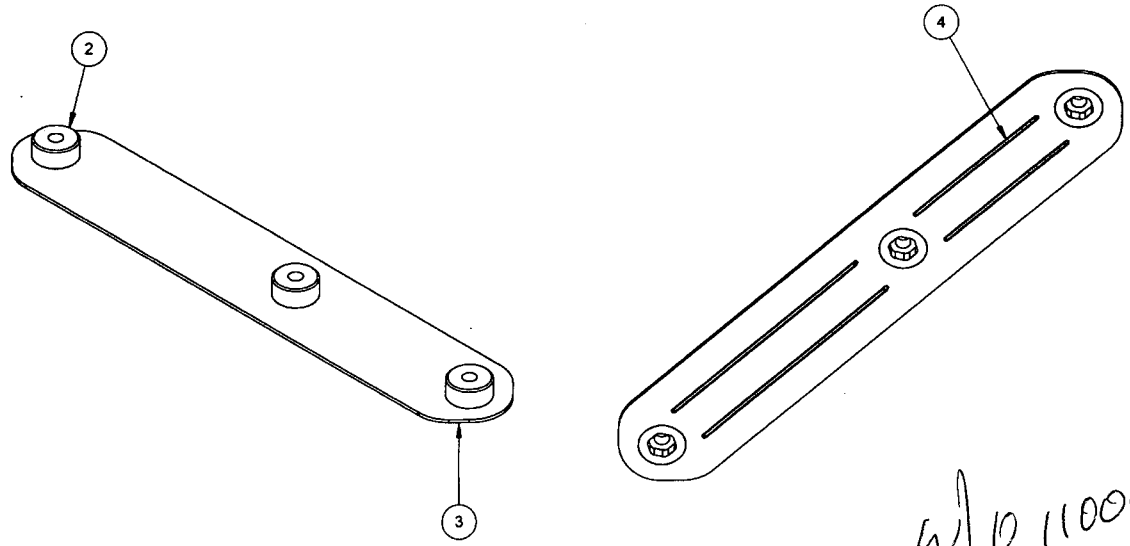
Comments: IPP REV:A 13.09.30 NEW ISSUE DD VERF:JLM IPP REV:B 13.11.10 AS PER REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No				sf	210.6540		7	7	13.12.16	

Location	Loc Qty	Loc Code
MAT020	210.6539998	
123136	140.2	
M126159	25.94	
M126915	44.514	

126915 → 7

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4952-041	WEARPLATE ASSEMBLY
2	3	D4379-3	WEARPLATE CUP
3	1	D4952-1	WEARPLATE
4	A/R	2059B	HARDCOAT



w/o 110000

RELEASED
2013-10-30

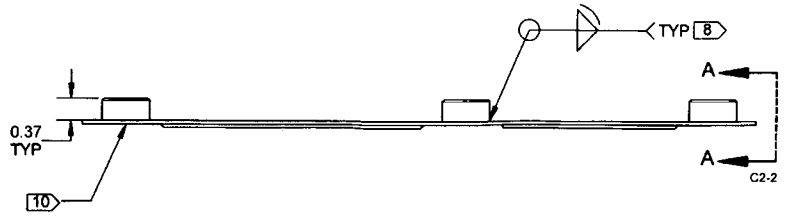
D4952-041 WEARPLATE ASSEMBLY

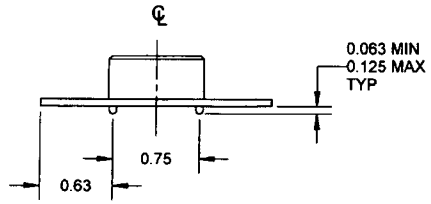
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	VS	13.09.23

APPROVED

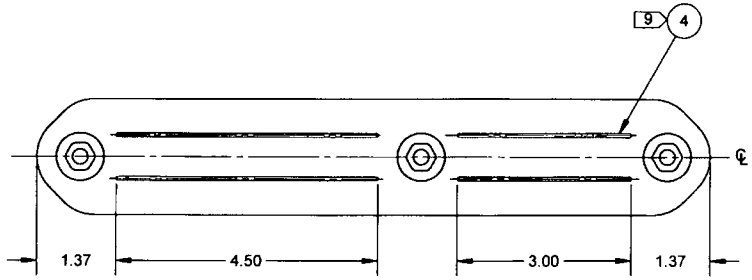
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VS	
CHECKED	DC	DRAWING NO. D4952 REV. A
MFG. APPR.	DD	SHEET 1 OF 3
APPROVED	HS	TITLE WEARPLATE SCALE NTS
DE APPR.	DS	
DATE	13.10.17	

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SECTION A-A
SCALE 1 : 1
C4-2



D4952-041 WEARPLATE ASSEMBLY
WELDING DETAIL

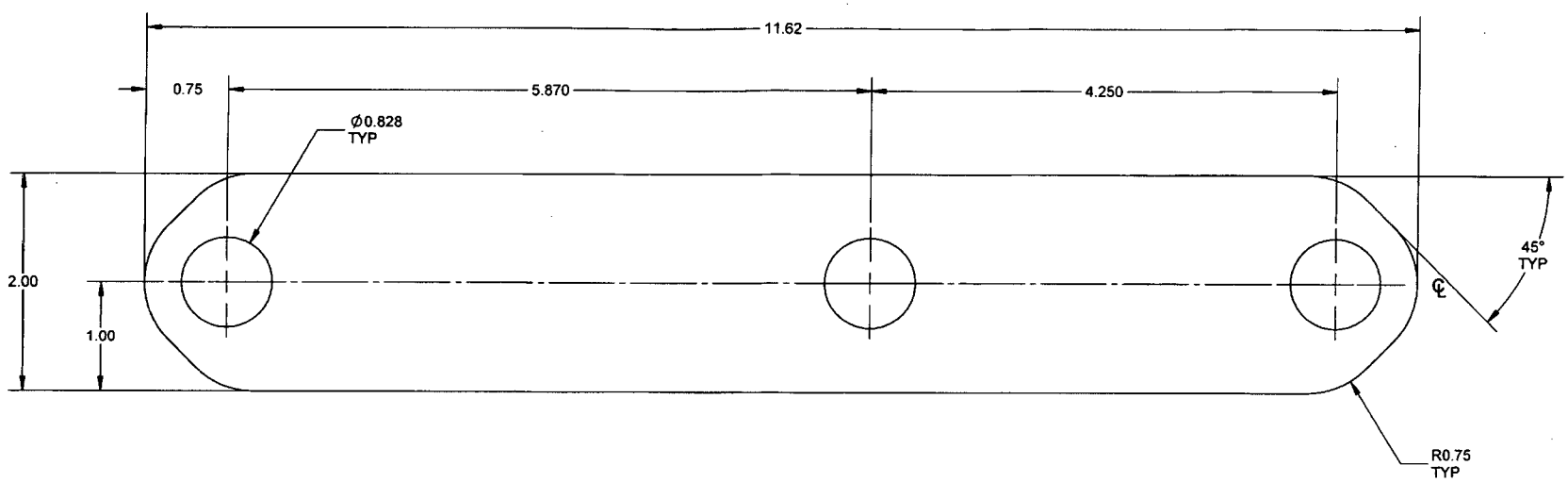
REC'D
2013 -10- 30

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: 0.44 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 4 PL
10) D4379-3 FLUSH WITH SURFACE

APPROVED

DESIGN	VS	**DART AEROSPACE LTD**
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA
CHECKED	DC	DRAWING NO. D4952 REV. A
MFG. APPR.	DD	SHEET 2 OF 3
APPROVED	HS	TITLE WEARPLATE SCALE NTS
DE APPR.	DS	
DATE 13.10.17		

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D4952-1 WEARPLATE

RELEASED
2013-10-30

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA
CHECKED	DC	DRAWING NO. D4952 REV. A
MFG. APPR.	DD	SHEET 3 OF 3
APPROVED	HS	TITLE WEARPLATE SCALE NTS
DE APPR.	DS	
DATE	13.10.17	

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DART AEROSPACE LTD	Work Order:	110000
Description: LEXAN PLATE	Part Number:	D4952-1
Inspection Dwg: 4952 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.62"	+/- .030	11.60	-		T	JKM-06
5.870"	+/- .010	5.870"	-		V	JKM-05
4.250"	+/- .010	4.250"	-		V	
2.00"	+/- .030	2.00"	-		V	
1.00"	+/- .030	1.00"	-		V	
.75"	+/- .030	.75"	-		V	
.063	+/- .010	.057"	-		V	
ø .828	+.010/-.001	.828	-		V	

DAS

Measured by:	Ac	Audited by:	27 9-89	Preliminary Approval:	
Date:	13.12.16	Date:	13/12/17	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15